

Work Order ID 133785

Wednesday, June 17, 2015 2:52:08 PM

133785

U/R *N/A*

Page 1

Item ID: D3883-2
 Revision ID: *N/A*
 Item Name: Saddle, Outboard RH

Accept

N9000040100

Setup Start

NS1

Stop

NS2

Start Date: 6/17/2015 Start Qty: 8.00

8

Cust Item ID:

Required Date: 6/17/2015 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: *MLS*

Date: *JUN 17 2015*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3883	D

100

100

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Program Batch No. *133785*

Double check by: *gmk*

1-Machine Step No 1 per Folio FA817 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA817 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA817 and inspect per Dimension Sheets

0.00

0.00

DAS

20

9-89

1507-30

15/08/06

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

DAS

20

9-89

1507-30

15/09/06

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Page 2

Hand Finishing

8 SLB-8-18

8 *ff* AUG 18 2015

Work Order ID 133785

Wednesday, June 17, 2015 2:52:08 PM

133785

Page 3

Item ID: D3883-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: U/R Stop ***NS2***
 Item Name: Saddle, Outboard RH
 Start Date: 6/17/2015 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 6/17/2015 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
140									
Powdercoat	Memo	0.00							
Powder Coating	***MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT AS PER INDICATED ON DWG (SEE NOTE 2)***								
	DO NOT MASK INSIDE FLANGE SURFACE								
	<i>n 130345</i>								
	START TIME: <i>12:00</i>								
	OVEN TEMPERATURE: <i>320°</i>								
	FINISH TIME: <i>12:20</i>								
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									

⑧

DAS
38
9-89
AUG 20 1989

Work Order ID 133785

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133785

Page 4

Item ID: D3883-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: U/R Stop ***NS2***
 Item Name: Saddle, Outboard RH
 Start Date: 6/17/2015 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 6/17/2015 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>ST404</u>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

DAS
6
9-89

⑧ JA AUG 20 2015

MLJ AUG 21 2015

MLJ AUG 20 2015

Picklist Print

Wednesday, June 17, 2015 2:52:12 PM

Page 1

Work Order ID: 133785

133785

Parent Item: D3883-2

D3883-2

Parent Item Name: Saddle, Outboard RH

Start Date: 6/17/2015

Required Date: 6/17/2015

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP RevA: New issue DD verified by:EC

IPP REV:B

15.05.20 remove inside powdercoat DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-015		Manufactured	No				Each	2.0000		8			
D6101-015									**	8		DAS 20 9-89	15-07-29
Saddle Billet													

Location

Loc Qty

Loc Code

MAT040

1

129885

1

MAT045

1

124323

1

134422

8

DART AEROSPACE LTD		Work Order:	133785
Description: Saddle, Outboard, RH		Part Number:	D3883-2
Inspection Dwg: D3883	Rev. C	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		.642	.643	.644	.644		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		.258	.258	.258	.258		
F	0.605	0.625		.609	.609	.611	.610		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.0045	2.003	2.0037	2.0046		
J	0.140	0.165		.144	.150	.149	.149		
K	0.240	0.260		.242	.248	.248	.248		
L	0.115	0.135		.125	.125	.125	.125		
M	0.140	0.165		.143	.149	.148	.148		
N	0.720	0.780		.760	.760	.760	.760		
O	0.240	0.260		.256	.250	.250	.250		
P	0.110	0.140		.140	.140	.140	.140		
Q	0.178	0.198		.188	.188	.188	.188		
R	2.825	2.885		2.855	2.855	2.855	2.855		
S	0.316	0.321		.316	.316	.316	.316		
T	0.990	1.010		1.004	1.008	.998	.996		
U	1.745	1.755		1.750	1.750	1.750	1.750		
V	5.990	6.010		6.000	6.000	6.000	6.000		
W	1.245	1.255		1.250	1.250	1.250	1.250		
X	0.490	0.510		.500	.502	.499	.501		
Y	1.220	1.280		1.230	1.230	1.230	1.230		
Z	2.495	2.505		2.500	2.500	2.500	2.500		
AA	0.313	0.318		.314	.314	.314	.314		
AB	0.020	0.040		.037	.035	.035	.035		
AC	0.760	0.765		.760	.760	.760	.760		
AD	0.215	0.220		.219	.218	.218	.218		
AE	1.265	1.285		1.270	1.268	1.2683	1.269		
AF									
Accept/Reject									

Measured by:	DAS 20	15-07-29
Date:	15/08/25	

Audited by:	J
Date:	15-8-18

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	ILM
B	09.11.25	Dimension AE added	KJ	

DART AEROSPACE LTD		Work Order: 133785
Description: Saddle, Outboard, RH		Part Number: D3883-2
Inspection Dwg: D3883	Rev. C	Page 1 of 1

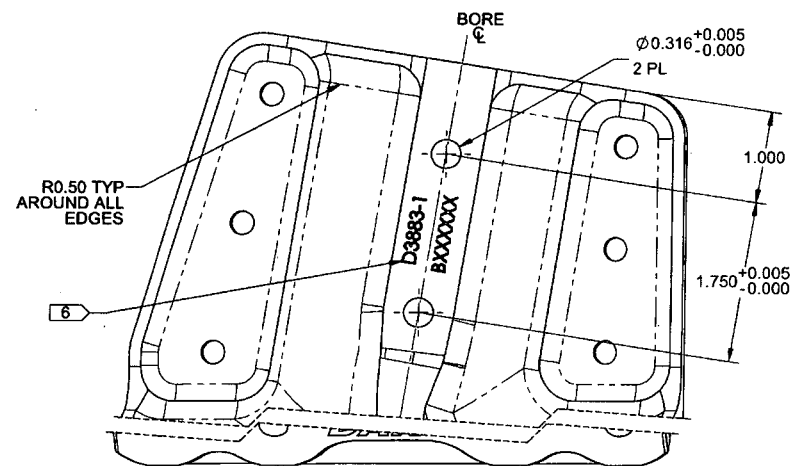
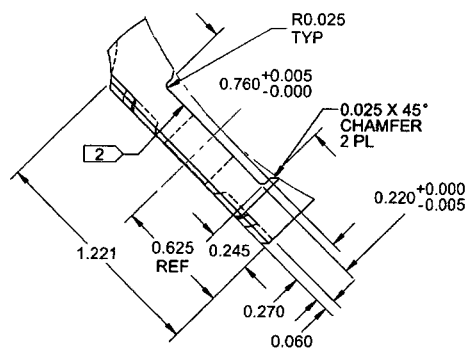
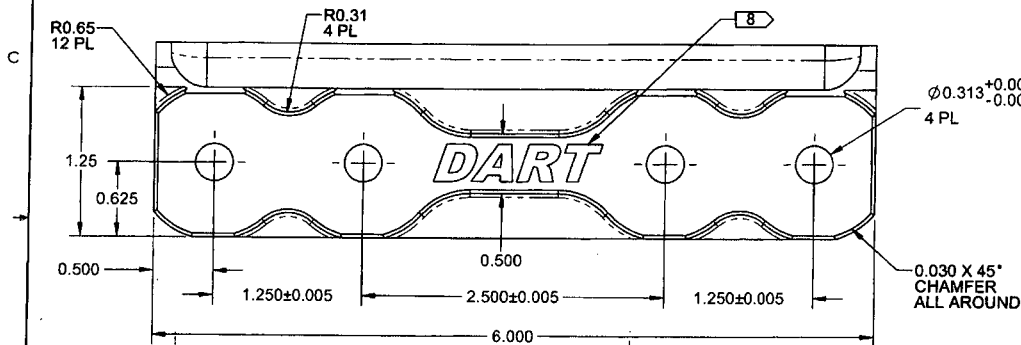
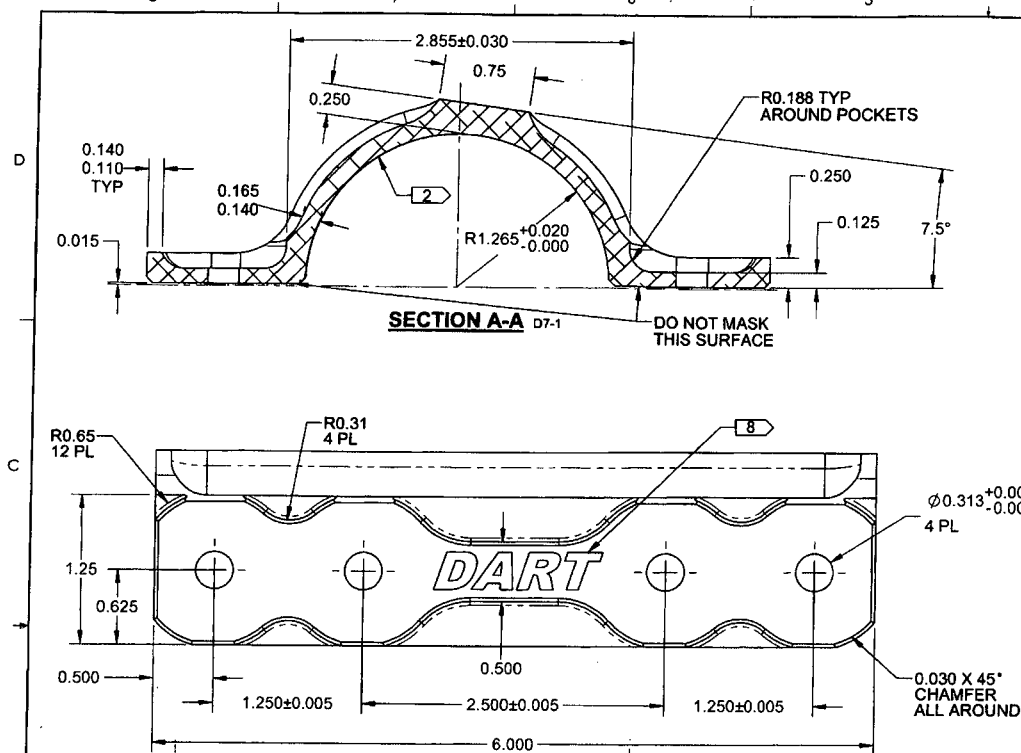
Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				51	67	77	81		
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		.643	.643	.645	.645		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		.258	.258	.258	.258		
F	0.605	0.625		.609	.611	.611	.611		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.004	2.004	2.0036	2.0035		
J	0.140	0.165		.149	.149	.150	.150		
K	0.240	0.260		.248	.248	.248	.247		
L	0.115	0.135		.126	.126	.125	.126		
M	0.140	0.165		.148	.149	.149	.149		
N	0.720	0.780		.760	.760	.760	.760		
O	0.240	0.260		.252	.251	.251	.251		
P	0.110	0.140		.140	.140	.140	.140		
Q	0.178	0.198		.188	.188	.188	.188		
R	2.825	2.885		2.855	2.855	2.855	2.855		
S	0.316	0.321		.316	.316	.316	.316		
T	0.990	1.010		.997	.998	.998	.998		
U	1.745	1.755		1.750	1.750	1.750	1.750		
V	5.990	6.010		6.000	6.000	6.000	6.000		
W	1.245	1.255		1.250	1.250	1.250	1.250		
X	0.490	0.510		.501	.500	.500	.500		
Y	1.220	1.280		1.230	1.230	1.230	1.230		
Z	2.495	2.505		2.500	2.500	2.500	2.500		
AA	0.313	0.318		.314	.314	.314	.314		
AB	0.020	0.040		.035	.035	.035	.035		
AC	0.760	0.765		.760	.760	.760	.760		
AD	0.215	0.220		.218	.218	.218	.218		
AE	1.265	1.285		1.2684	1.268	1.268	1.268		
AF									
Accept/Reject									

Measured by:	DAS
Date:	15-07-30

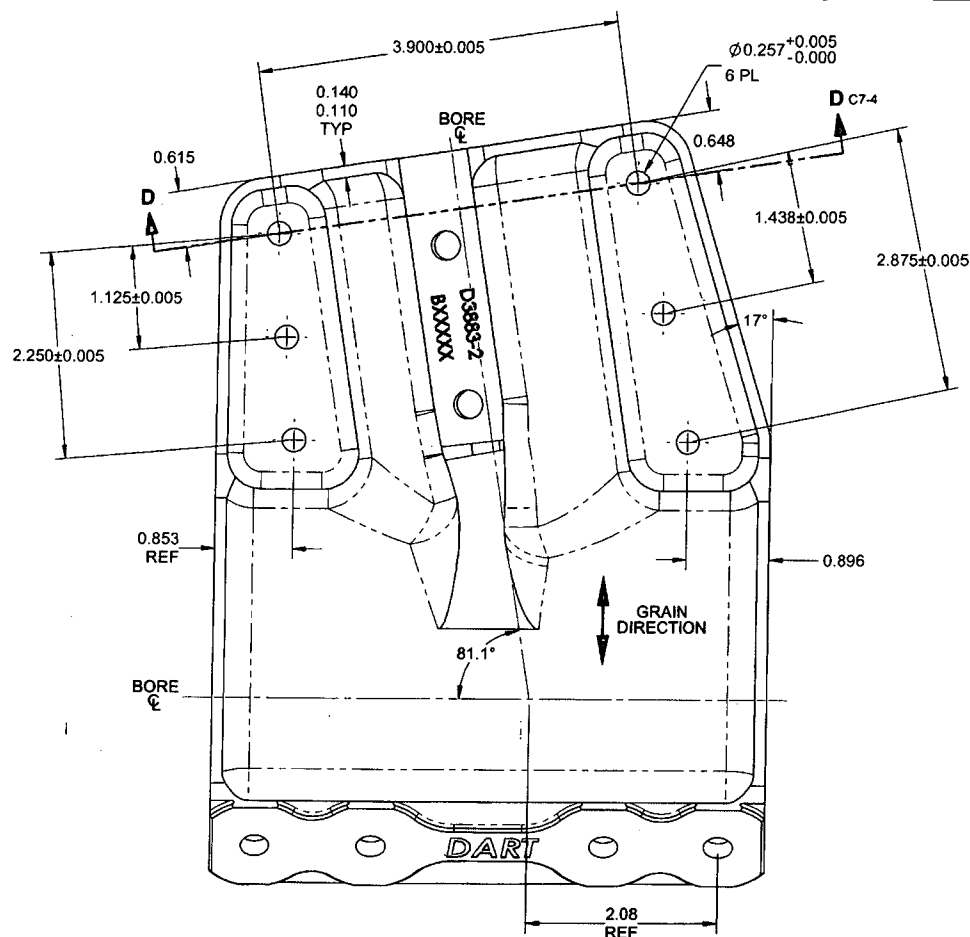
Audited by:	JL
Date:	15-8-18

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	JLM
B	09.11.25	Dimension AE added	KJ	



RELEASED
A.R. 2015 MAY 19

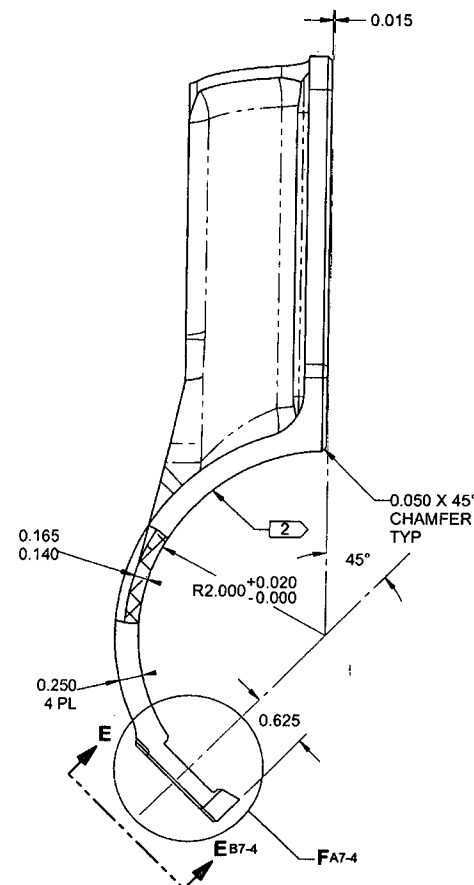
APPROVED	DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
	DRAWN	AP		
	CHECKED	AJS	DRAWING NO.	REV. D
	MFG. APPR.	JLM	D3883	SHEET 2 OF 4
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	OUTBOARD SADDLE	NTS
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D3883-2 SADDLE, OUTBOARD RH

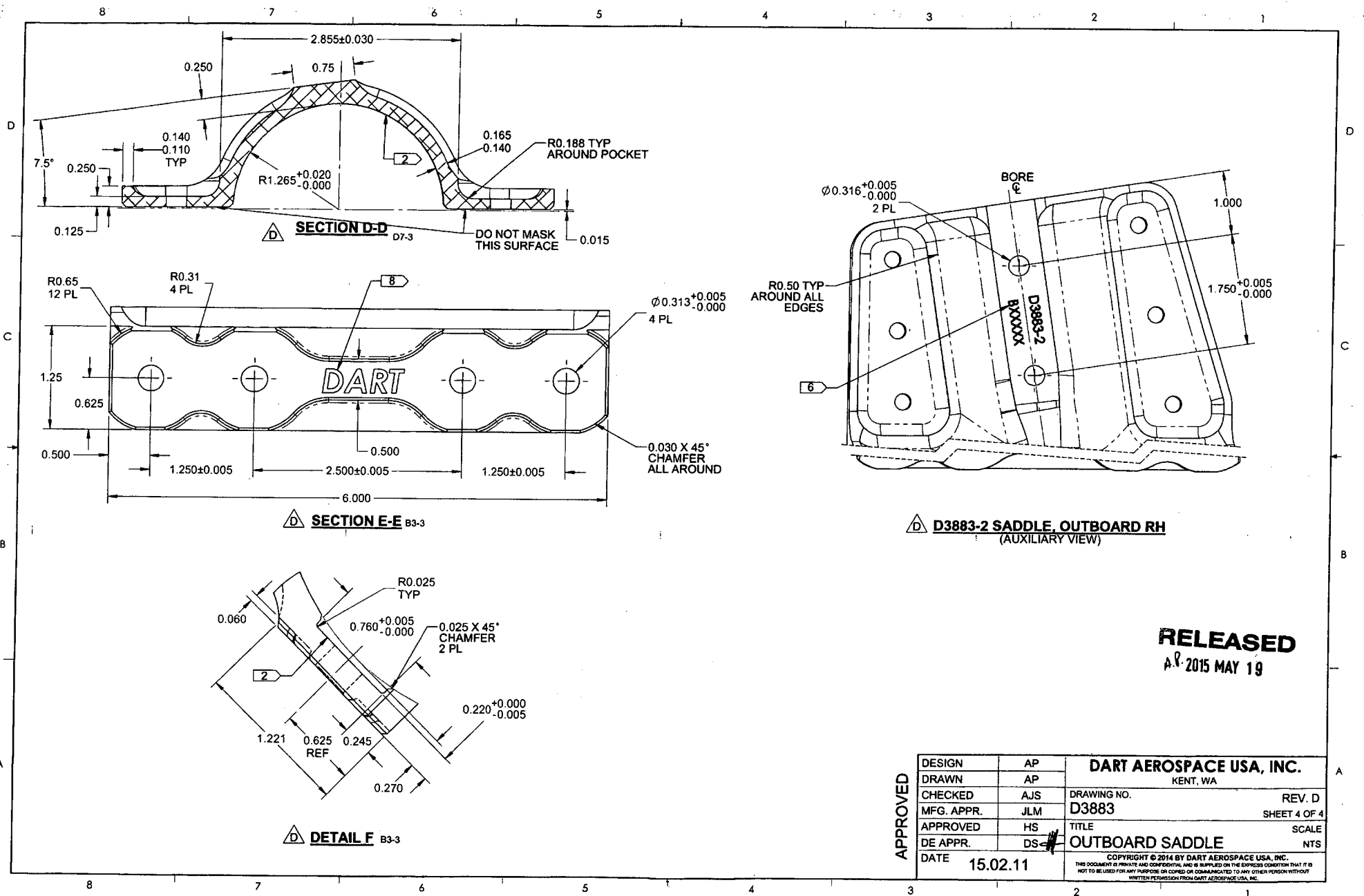
NOTES:

- 1) MATERIAL: 7075-T7351 ALUMINUM PER AMS-QQ-A-250/12, OR QQ-A-250/12 OR ASTM B209 (REF DART SPEC. D6101-015)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 1.03 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD R0.250
- 9) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D3883-2-REV.D.SLDPRT"



RELEASED
APR 2015 MAY 19

APPROVED	DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
	DRAWN	AP		
	CHECKED	AJS	DRAWING NO.	REV. D
	MFG. APPR.	JLM	D3883	SHEET 3 OF 4
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	OUTBOARD SADDLE	NTS
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RELEASED
A.P. 2015 MAY 19

APPROVED	DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
	DRAWN	AP		
	CHECKED	AJS	DRAWING NO.	REV. D
	MFG. APPR.	JLM	D3883	SHEET 4 OF 4
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	OUTBOARD SADDLE	NTS
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Part Number: D3883-2	Rev: D	- Page 1 -
Description: OUTBOARD SADDLE	Inspection Dwg: D3883	Work Order: 133785

Item Ref.	Nominal	Tolerance	No. Piece_1 Actual	No. Piece_2 Actual	No. Piece_3 Actual	No. Piece_4 Actual	
1	2.8750	+0.0050/-0.0050	2.8756	2.8768	2.8763	2.8763	
2	17.0000	+0.5000/-0.5000	16.7876	16.7871	16.7882	16.7910	
3	1.4380	+0.0050/-0.0050	1.4382	1.4393	1.4382	1.4380	
4	0.6480	+0.0100/-0.0100	0.6499	0.6490	0.6501	0.6497	
5	3.9000	+0.0050/-0.0050	3.8977	3.8972	3.8981	3.8987	
6	0.2570	+0.0050/0.0000	0.2576	0.2570	0.2576	0.2573	
7	0.6150	+0.0100/-0.0100	0.6175	0.6173	0.6173	0.6169	
8	1.1250	+0.0050/-0.0050	1.1254	1.1247	1.1246	1.1250	
9	2.2500	+0.0050/-0.0050	2.2511	2.2503	2.2509	2.2507	
10	0.8530	+0.0100/-0.0100	0.8548	0.8546	0.8548	0.8549	
11	81.1000	+0.5000/-0.5000	81.0860	81.0877	81.0843	81.0840	
12	2.0800	+0.0300/-0.0300	2.0818	2.0809	2.0806	2.0817	
13	0.8960	+0.0100/-0.0100	0.8965	0.8968	0.8971	0.8963	
14	0.0150	+0.0100/-0.0100	0.0106	0.0109	0.0104	0.0091	
D15	0.050	+0.010/-0.010	0.047	0.046	0.045	0.045	
16	45.0000	+0.5000/-0.5000	45.0297	45.0796	45.0485	45.0512	
17	0.6250	+0.0100/-0.0100	0.6276	0.6273	0.6273	0.6277	
D18	0.250	+0.010/-0.010	0.247	0.247	0.247	0.247	
D19	0.140	+0.025/0.000	0.150	0.150	0.149	0.149	
16	2.0000	+0.0200/0.0000	2.0000	2.0000	2.0000	2.0000	
21	0.1250	+0.0100/-0.0100	0.1271	0.1272	0.1272	0.1274	
D22	0.188	+0.010/-0.010	0.188	0.188	0.188	0.188	
23	1.2650	+0.0200/0.0000	1.2650	1.2650	1.2650	1.2650	
24	0.0150	+0.0100/-0.0100	0.0101	0.0104	0.0101	0.0095	
25	0.2500	+0.0100/-0.0100	0.2518	0.2516	0.2514	0.2517	
D26	0.125	+0.015/-0.015	0.138	0.139	0.139	0.140	
D27	0.250	+0.010/-0.010	0.252	0.251	0.250	0.251	
D28	2.855	+0.030/-0.030	2.856	2.855	2.855	2.855	
D29	0.750	+0.030/-0.030	0.765	0.763	0.760	0.760	
D30	0.140	+0.025/0.000	0.149	0.148	0.148	0.148	
31	7.5000	+0.5000/-0.5000	7.4988	7.5059	7.5105	7.5146	

Measured by:
Mathieu Lamarche

Date:
2015-8-17

Audited by:

Date:



Part Number: D3883-2	Rev: D	- Page 2 -
Description: OUTBOARD SADDLE	Inspection Dwg: D3883	Work Order: 133785

Item Ref.	Nominal	Tolerance	No. Piece_1 Actual	No. Piece_2 Actual	No. Piece_3 Actual	No. Piece_4 Actual	
32	0.3160	+0.0050/0.0000	0.3160	0.3160	0.3160	0.3160	
33	1.0000	+0.0100/-0.0100	0.9969	0.9964	0.9968	0.9967	
34	1.7500	+0.0050/0.0000	1.7503	1.7500	1.7501	1.7503	
D35	0.245	+0.010/-0.010	0.245	0.246	0.246	0.247	
D36	0.760	+0.005/0.000	0.761	0.760	0.760	0.761	
D37	0.220	+0.000/-0.005	0.219	0.218	0.218	0.218	
D38	1.221	+0.010/-0.010	1.230	1.228	1.230	1.230	
39	0.0600	+0.0100/-0.0100	0.0598	0.0597	0.0599	0.0598	
D40	1.250	+0.030/-0.030	1.250	1.250	1.250	1.250	
41	0.5000	+0.0100/-0.0100	0.5026	0.5013	0.5016	0.5025	
42	1.2500	+0.0050/-0.0050	1.2510	1.2503	1.2500	1.2496	
D43	0.500	+0.010/-0.010	0.500	0.500	0.500	0.501	
44	2.5000	+0.0050/-0.0050	2.4971	2.5001	2.4993	2.4993	
45	6.0000	+0.0100/-0.0100	6.0012	6.0016	6.0014	6.0015	
46	1.2500	+0.0050/-0.0050	1.2510	1.2494	1.2494	1.2500	
D47	0.030	+0.010/-0.010	0.030	0.030	0.030	0.030	
48	0.3130	+0.0050/0.0000	0.3130	0.3130	0.3130	0.3130	

Measured by:
Mathieu Lamarche

Date:
2015-8-17

Audited by:

Date:



Part Number: D3883-2	Rev: D	- Page 1 -
Description: OUTBOARD SADDLE	Inspection Dwg: D3883	Work Order: 133785

Item Ref.	Nominal	Tolerance	No. Piece_5 Actual	No. Piece_6 Actual	No. Piece_7 Actual	No. Piece_8 Actual	
1	2.8750	+0.0050/-0.0050	2.8765	2.8763	2.8758	2.8762	
2	17.0000	+0.5000/-0.5000	16.7934	16.7869	16.7910	16.7740	
3	1.4380	+0.0050/-0.0050	1.4384	1.4384	1.4378	1.4387	
4	0.6480	+0.0100/-0.0100	0.6494	0.6499	0.6498	0.6483	
5	3.9000	+0.0050/-0.0050	3.8995	3.8984	3.8980	3.8975	
6	0.2570	+0.0050/0.0000	0.2570	0.2573	0.2575	0.2570	
7	0.6150	+0.0100/-0.0100	0.6158	0.6167	0.6159	0.6163	
8	1.1250	+0.0050/-0.0050	1.1248	1.1248	1.1250	1.1250	
9	2.2500	+0.0050/-0.0050	2.2502	2.2508	2.2502	2.2505	
10	0.8530	+0.0100/-0.0100	0.8545	0.8556	0.8547	0.8538	
11	81.1000	+0.5000/-0.5000	81.0854	81.0883	81.0852	81.0849	
12	2.0800	+0.0300/-0.0300	2.0817	2.0803	2.0839	2.0830	
13	0.8960	+0.0100/-0.0100	0.8967	0.8963	0.8965	0.8961	
14	0.0150	+0.0100/-0.0100	0.0097	0.0089	0.0103	0.0073	
D15	0.050	+0.010/-0.010	0.042	0.045	0.044	0.045	
16	45.0000	+0.5000/-0.5000	45.0357	45.0557	45.0444	45.0278	
17	0.6250	+0.0100/-0.0100	0.6267	0.6277	0.6266	0.6264	
D18	0.250	+0.010/-0.010	0.247	0.247	0.247	0.247	
D19	0.140	+0.025/0.000	0.149	0.148	0.148	0.148	
16	2.0000	+0.0200/0.0000	2.0000	2.0000	2.0000	2.0000	
21	0.1250	+0.0100/-0.0100	0.1277	0.1274	0.1274	0.1297	
D22	0.188	+0.010/-0.010	0.188	0.188	0.188	0.188	
23	1.2650	+0.0200/0.0000	1.2650	1.2650	1.2650	1.2650	
24	0.0150	+0.0100/-0.0100	0.0101	0.0103	0.0100	0.0088	
25	0.2500	+0.0100/-0.0100	0.2523	0.2520	0.2520	0.2520	
D26	0.125	+0.015/-0.015	0.139	0.139	0.139	0.139	
D27	0.250	+0.010/-0.010	0.253	0.250	0.250	0.250	
D28	2.855	+0.030/-0.030	2.855	2.855	2.855	2.855	
D29	0.750	+0.030/-0.030	0.760	0.760	0.760	0.760	
D30	0.140	+0.025/0.000	0.148	0.149	0.148	0.149	
31	7.5000	+0.5000/-0.5000	7.5006	7.5001	7.5063	7.5025	

Measured by:
Mathieu Lamarche

Date:
2015-8-17

Audited by:

Date:



Part Number: D3883-2	Rev: D	- Page 2 -
Description: OUTBOARD SADDLE	Inspection Dwg: D3883	Work Order: 133785

Item Ref.	Nominal	Tolerance	No. Piece_5 Actual	No. Piece_6 Actual	No. Piece_7 Actual	No. Piece_8 Actual	
32	0.3160	+0.0050/0.0000	0.3160	0.3160	0.3160	0.3160	
33	1.0000	+0.0100/-0.0100	0.9962	0.9972	1.0027	1.0028	
34	1.7500	+0.0050/0.0000	1.7500	1.7500	1.7503	1.7500	
D35	0.245	+0.010/-0.010	0.243	0.245	0.242	0.245	
D36	0.760	+0.005/0.000	0.760	0.760	0.760	0.760	
D37	0.220	+0.000/-0.005	0.218	0.218	0.218	0.218	
D38	1.221	+0.010/-0.010	1.230	1.230	1.230	1.230	
39	0.0600	+0.0100/-0.0100	0.0600	0.0598	0.0602	0.0600	
D40	1.250	+0.030/-0.030	1.250	1.250	1.250	1.250	
41	0.5000	+0.0100/-0.0100	0.5022	0.5016	0.5039	0.5027	
42	1.2500	+0.0050/-0.0050	1.2497	1.2505	1.2508	1.2491	
D43	0.500	+0.010/-0.010	0.500	0.500	0.500	0.500	
44	2.5000	+0.0050/-0.0050	2.5000	2.4994	2.4991	2.4996	
45	6.0000	+0.0100/-0.0100	6.0016	6.0014	6.0012	5.9992	
46	1.2500	+0.0050/-0.0050	1.2500	1.2484	1.2497	1.2498	
D47	0.030	+0.010/-0.010	0.030	0.030	0.030	0.030	
48	0.3130	+0.0050/0.0000	0.3130	0.3130	0.3130	0.3130	

Measured by:
Mathieu Lamarche

Date:
2015-8-17

Audited by:

Date: